Trolley

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1 General

The trolleys have **black** or **chromium-plated** castors. Pay attention to the different tightening torques of the castors.

1.1 Trolley with chromium-plated castors

1. Check that the castors are tightened with a setting of the torque wrench of 33 Nm (11.07 kg-ft).
2. If the castor is not tightened to 33 Nm (i.e. the caster bolt turns prior to reach 33 Nm) then the castor and the split washer shall be replaced.
3. Unscrew all castors.
4. Inspect for visible damage to castor bolts including a visual inspection to see if castor bolts are bent. Replace all damaged castors that have a visibly bent bolt.
5. If strain washers are found on the castor bolts replace them with split washers.
6. If Loctite is applied to the threads of the removed castors recut the threads in the trolley with a tap M10 without using oil or grease and clean threads of castors with alcohol.
7. Install castors with split washers using Loctite 221 on the threads.

8 Tighten caster bolts using a setting of the torque wrench of 38 Nm (28.1 lb-ft).

1.2 Trolley with black castors

1 Check that the castors are tightened with a setting of the torque wrench of 35 Nm (25.9 lb-ft).

2 If the castor is not tightened to 35 Nm (i.e. the castor bolt turns prior to reach 35 Nm) then the castor and the strain washer shall be replaced.

3 Unscrew all castors.

4 Inspect for visible damage to castor bolts including a visual inspection to see if castor bolts are bent. Replace all damaged castors that have a visibly bent bolt.

5 If split washers are available on the castor bolts replace them with strain washers, see figure below.

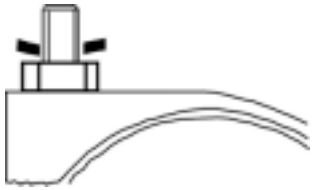

Fig. 1 Castor bolts

6 If Loctite is applied to the threads of the removed castors recut the threads in the trolley with a tap M10 without using oil or grease and clean threads of castors with alcohol.

7 Install castors with strain washers using Loctite 221 on the threads.

8 Tighten castor bolts using a setting of the torque wrench of 40 Nm (26.6 lb-ft).

1.3 Tools

- Torque wrench 20 to 100 Nm	7910132
- Torque wrench 5 to 50 Nm	7900909
Note: either torque wrench may be used, however if you do not already have either torque wrench, then order P/N 7910132	
Additional tools for chromium-plated castors:	
- Special open-ended wrench, size 27 mm	7901607
- Loctite 221	7901966
- Tap M10	7910235

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Additional tools for black castors:	
- Special open-ended wrench, size 17 mm	7901204

1.4 Trolley with black castors

Castor	2M19130
Lockable castor	2M19140
Strain washer	1341146

1.5 Trolley with chromium-plated castors

Castor	M24130
Lockable castor	M24252
Split washer	1335219

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